

Work Order ID 57889

Monday, April 19, 2010 3:35:26 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 4/19/2010 Start Qty: 1.00

Required Date: 4/26/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 10/4/20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

10/05/06

for BG 10/05/05

57889

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Page 2

Item ID: D350-636-012

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Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 4/19/2010 Start Qty: 1.00



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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ ☐ Aluminum Rod

☐ M113207

BE 10/04/22

10-Grind welds flush as per Dwg D2750

DD 10-4-22

DD 10-4-21

K10/4/22

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
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DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11- scribe batch #.

N10/4/22

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 10/6/22

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/6/22

TC

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DP 10-4-23

Work Order ID 57889

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Item ID: D350-636-012

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Start Date: 4/19/2010 Start Qty: 1.00



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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 4/10/4/22

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Page 5

Item ID: D350-636-012

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Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Skidtubes	Skidtubes	0.00							
Skidtubes	<p>Memo</p> <p>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</p> <p>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</p> <p>3-Open float holes to .500" (4 per Side)</p> <p>4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6-Prepare tube for welding, remove alodine as required.</p> <p>7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/><input type="checkbox"/><input type="checkbox"/> Sikaflex-291 batch: 112417 <input type="checkbox"/><input type="checkbox"/> exp. date: 10-8-20</p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/><input type="checkbox"/><input type="checkbox"/> Aluminum Rod batch: M113207</p> <p>9-Grind welds flush as per Dwg D2750</p> <p>10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750</p>								

11/10/4/23

ANM 10-4-26

86 10/04/27

) 11/10/4/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- At section AJ-AJ drill out x-bolt spacer to 0.404" BE 10/04/27

12-Deburr holes

K 10/14/27

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

Memo

S 10/04/27

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 10/04/27



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Customer:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



HandFinish

Pressure Wash per QSI005 4.3

0.00

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

① BR 10-4-28.

200



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powder Coating

Memo

0.00

START TIME: 10:30AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:00AM

⇒ M 10/04/28

1

210



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

Inspect for foreign object per QSI 024

① BR 10-4-30

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

① BR 10-4-30.

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: _____3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: 1112429

EXP DATE: 10/10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 1141895-Coat all exposed fasteners with "LPS Procyon"
batch: 104251

① . BR 10-5-3.

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NOTE: Date & initial all entries

Monday, April 19, 2010 3:35:26 PM

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[illegible]

100-443887-1000

[illegible]

11/11/11

Abstract

**SPC (Y/N):**

Date: _____

**Insp.
Stamp**

8/10/05/01

0.00

20

- 0.00

10-8.5 S

0.00

6/05/06

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10-5-6sf

10/05/07

MF 10-5-6

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225



Insert

Purchased No 220 Each 7,689.000 38.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

PK011

110768 ✓

7689

7689

230

Each

883.0000 34.0000



38 BK 10-5-4

AN3C5A



Bolt

Purchased No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST350

114330 ✓

500

500

Main Warehouse

ST351

383

113121

53

114056

179

114108

51

114181

100

34 BK 10-5-4

W/O:		WORK ORDER CHANGES					
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 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C6A



BOLT

Purchased No 230 Each 679.0000 4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

111982 ✓

679

679

230 . . . Each

53.0000 4.0000



H. BL 10-5-4.

AN6C44A



BOLT

Purchased No

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST344

51

111605

1

111649 ✓

50

H. BL 10-5-4.

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Shop Packet Print

Page 2

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 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

AN8C35A



BOLT

Purchased No 230 Each 19.0000 1.0000

Warehouse Location Loc Qty Loc Code

Main Warehouse

FP 110847 ✓ 19

AN960C10L



washer

AN960C816L



WASHER

Purchased No 230 Each 0.0000 38.0000
 Purchased No 290 Each 146.0000 1.0000

10 AS 1149C 0332R 114341

Warehouse Location Loc Qty Loc Code

Main Warehouse

ST348 146
 110584 100
 111424 ✓ 46

1 BL 10-5-4

38 BL 10-5-4

1 BL 10-5-4

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Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D2745



Bushing

Manufactured No 230 Each 150.0000 8.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST023

150

52311 ✓

150

D3488-042



Blade Fitting Assembly, RH

Manufactured No 230 Each 27.0000 1.0000



8 BR 10-5-4.

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

52666 ✓

7

Main Warehouse

FP008

20

53918

20

1 BR 10-5-4.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3492-041

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

55446

42

Main Warehouse

FP031

40

57517 ✓

40

D3492-043

Manufactured No

230

Each

82.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

42

54682 ✓

42

Main Warehouse

FP013

40

57519

40

8. BR 105-4

8. BR 105-4.

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

16.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

16

56065

4

56839 ✓

12

230

Each

10.0000

1.0000

D3536-25

Manufactured No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP10

10

54479 ✓

10

1 BL 10-5-4.

1 BL 10-5-4.

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Page 7

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Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 63.0000 3.0000
 Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 575U 9
 55465 9

Main Warehouse

FP17 54
 57510 54

3 BR 10-5-4.

D3631-1 Manufactured No 230 Each 302.0000 8.0000
 Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST076 302
 52693 302

8 BR 10-5-4.

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Page 8

Work Order ID: 57889



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments:

IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev: J 06-03-29 As per Rev D EC

IPP Rev: K 06-07.13 As per dsi9343 EC

IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D3672-1

Manufactured No

230

Each

1,589.000 4.0000



Phenolic Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

1589

47628 ✓

89

51674

500

52505

1000

H. BR 10-5-4

D3791-1

Manufactured No

230

Each

18.0000 1.0000



Wearplate



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

7

55457 ✓

7

Main Warehouse

FP17

11

56299

11

H. BR 10-5-4

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Page 8

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Page 9

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-1



Wearshoe

Manufactured No 230 Each 14.0000 1.0000

Warehouse
Location

Main Warehouse

FP18

51597

56300 ✓

14

2

12

230

Each

10.0000

1.0000



1 BL 10-5-14.

D3793-3



Wearshoe

Manufactured No

Warehouse
Location

Main Warehouse

FP19

55458 ✓

10

10

1 BL 10-5-14.

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Page 10

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3794-1



Gasket

Manufactured No 230 Each 19.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

7

55459 ✓

7

Main Warehouse

FP014

12

57537

12

D3794-3



Gasket

Manufactured No 230 Each 27.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

4

51907

4

Main Warehouse

FP18

23

56066 ✓

23

1 BR 10-5-11

1 BR 10-5-11

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Page 11

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

MS21043-6



NUT

Purchased No 230 Each 878.0000 4.0000



Warehouse
Location

Main Warehouse

ST301 878

112314 878

MS21083C8



NUT

Purchased No 230 Each 50.0000 1.0000



Warehouse
Location

Main Warehouse

ST303 50

113845 50

NAS1611-010



O-RING

Purchased No 230 Each 330.0000 8.0000



Warehouse
Location

Main Warehouse

FP 330

110715 100

110915 230

4 BR 10-5-4

1 BR 10-5-4

PTO -D

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Dart Aerospace Ltd

W/O: 57889		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-5-3	230	CHANGE O-RINGS D 2594-3 BATCH 58191.	BK	10-5-3	8.		<i>[Signature]</i> 10/05/06

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 12

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013



O-RING

Purchased No 230 Each 41.0000 8.0000

Warehouse
Location

Main Warehouse

FP

114451

41

41

Each

99.0000

2.0000

8. 6/10-5-4.
10-5-5

AN8C21A



BOLT

Purchased No

250

Each

99.0000

2.0000

Warehouse
Location

Main Warehouse

ST345

99

111605

49

113558

50

250

Each

146.0000

2.0000

2
10-5-5

AN960C816L



WASHER

Purchased No

Warehouse
Location

Main Warehouse

ST348

146

110584

100

111424

46

2

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Page 13

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D2741



Blade, 350 Skidtube

Manufactured No 250 Each 43.0000 1.0000



10-5-5 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST466

43

51931

11

55905

32

Manufactured No

250 Each 19.0000 2.0000



BS7825 10-5-5

D3493-1



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST224

19

47710

19

Manufactured No

250 Each 51.0000 2.0000



10-5-5

D3532-1



Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST068

51

52321

51

2

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Page 14

Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-13



Phenolic Washer

Purchased No 250 Each 920.0000 2.0000



10-5-5 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST077

920

54363

920

MS21083C8



NUT

Purchased No 250 Each 50.0000 2.0000



2
10-5-5 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST303

50

113845

50

D2600-3-BENT



Extrusion Bent

Manufactured No 110 Each 3.0000 1.0000



2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

3

55462

3

B 57538

① 11/10/4/22

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Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I ☐ 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

D2744 Manufactured No 110 Each 40.0000 1.0000



Cap

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 40
 47488 21
 51922 19

1 11/04/22

D2739 Manufactured No 160 Each 7.0000 1.0000



350 I Beam

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 7
 55986 1
 56060 6

B-57948^① AWM 10-4-26

D2743 Manufactured No 160 Each 130.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 130
 50281 50
 52310 80

8 BE 10/04/27

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Work Order ID: 57889

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Date: 4/19/2010

Required Date: 4/26/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-3



Cross Bolt Spacer

Manufactured No 160 Each 40.0000 4.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

55010

40

40

160

Each

73.0000

4.0000

4 BE 10/04/27

D3490-1



Cross Bolt Spacer

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

51932

57723

73

8

65

4 BE 10/04/27

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
	8		8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57889

C210/4/20

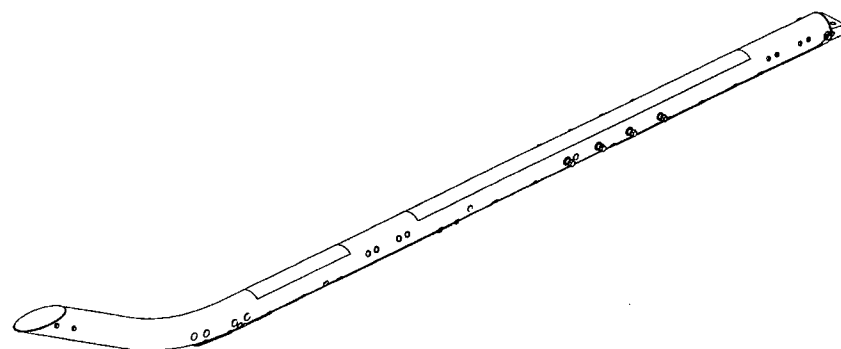
RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/RAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	RL		
CHECKED			
MFG. APPR.	AS		
APPROVED			
DE APPR.			
DATE	08.07.16		

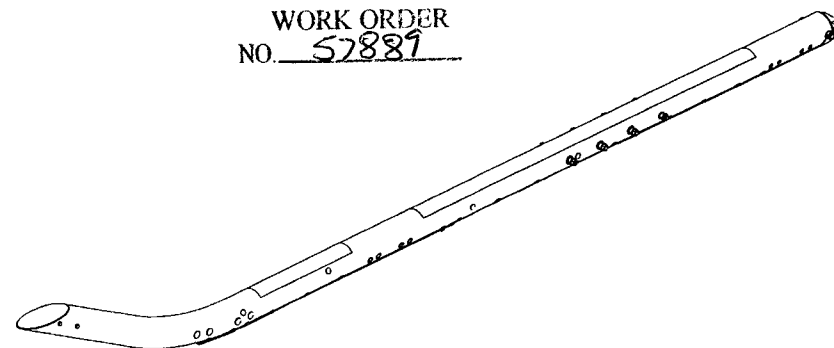
DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS

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 WORK ORDER
 NO. 57887



D2750-041 350 SKIDTUBE ASSEMBLY, LH

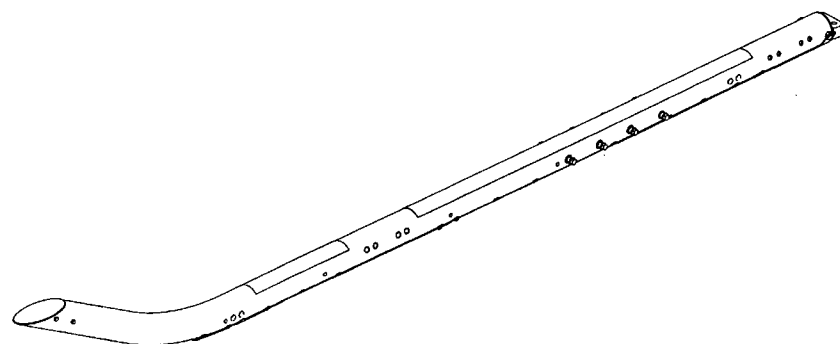


D2750-042 350 SKIDTUBE ASSEMBLY, RH

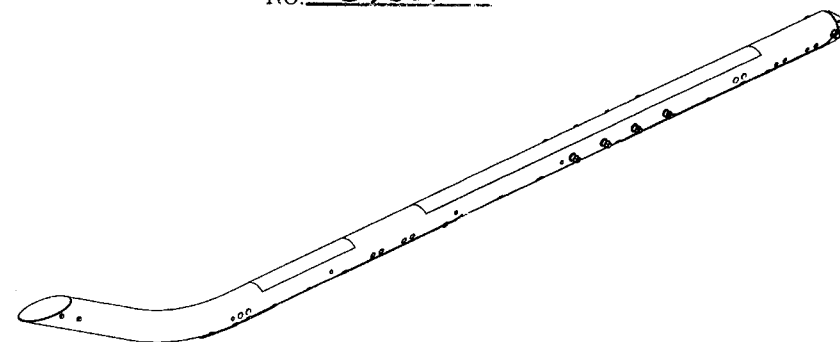
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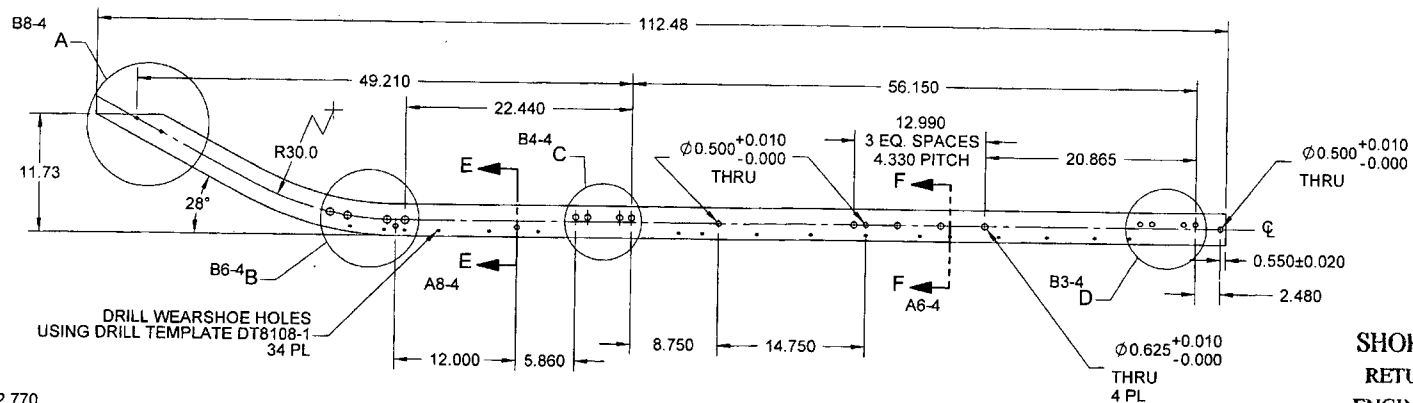
D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

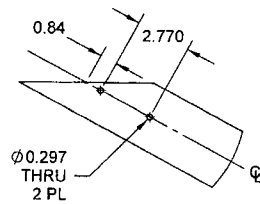
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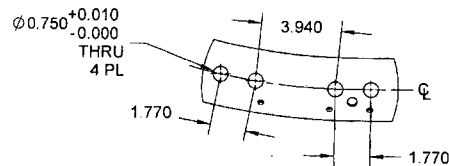


D2750-1 LH SKIDTUBE

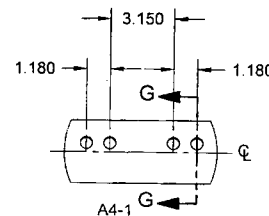
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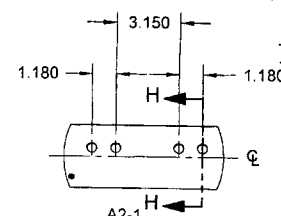
DETAIL A
SCALE 2X



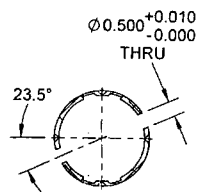
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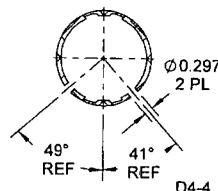
DETAIL C
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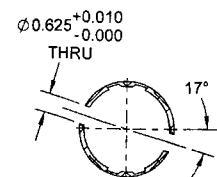
DETAIL D
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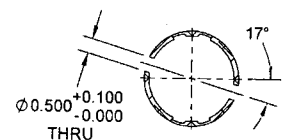
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



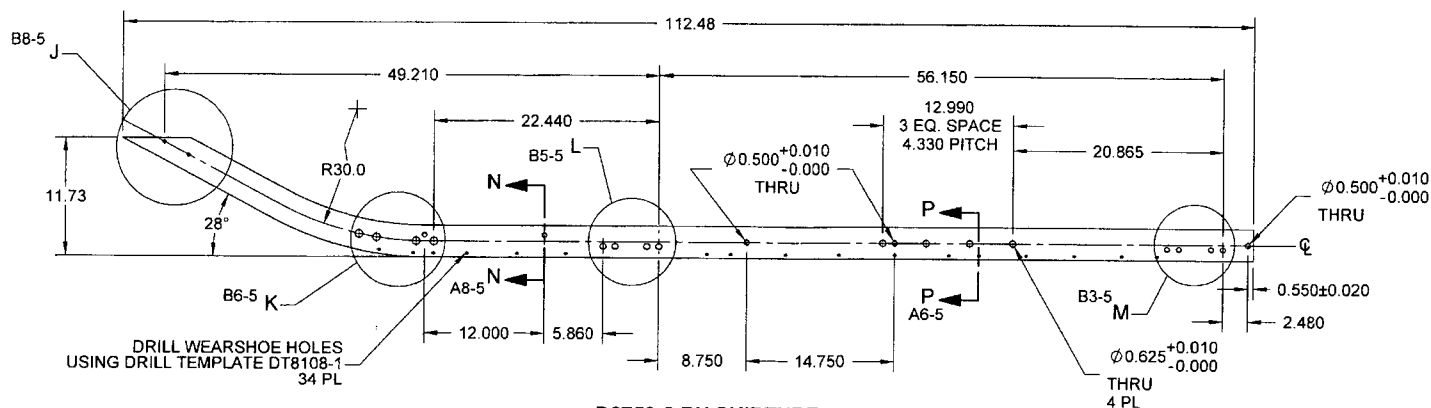
SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

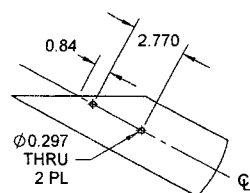
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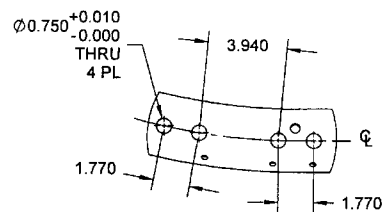


D2750-2 RH SKIDTUBE

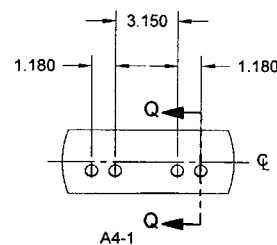
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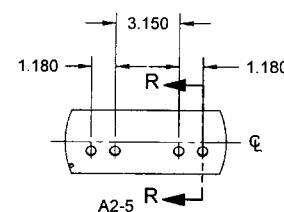
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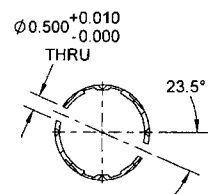
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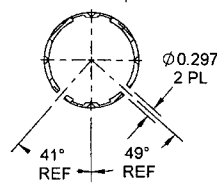
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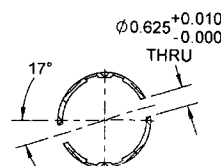
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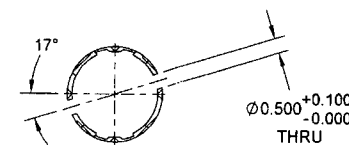
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



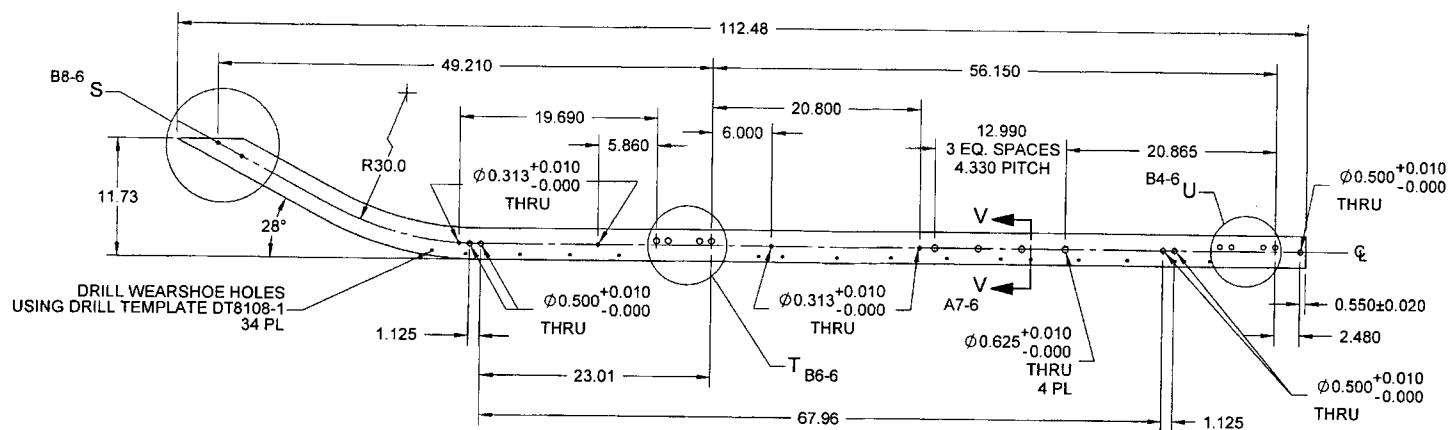
SECTION Q-Q
SCALE 3X, 4 PL



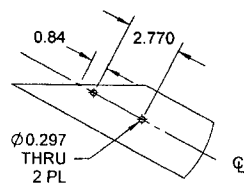
SECTION R-R
SCALE 3X, 4 PL

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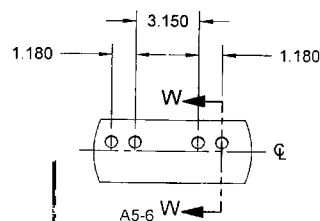
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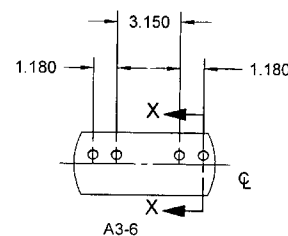
D2750-3 LH SKIDTUBE



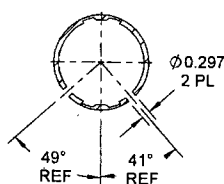
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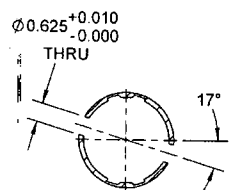
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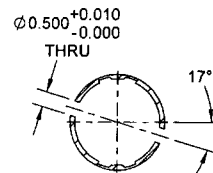
DETAIL U
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

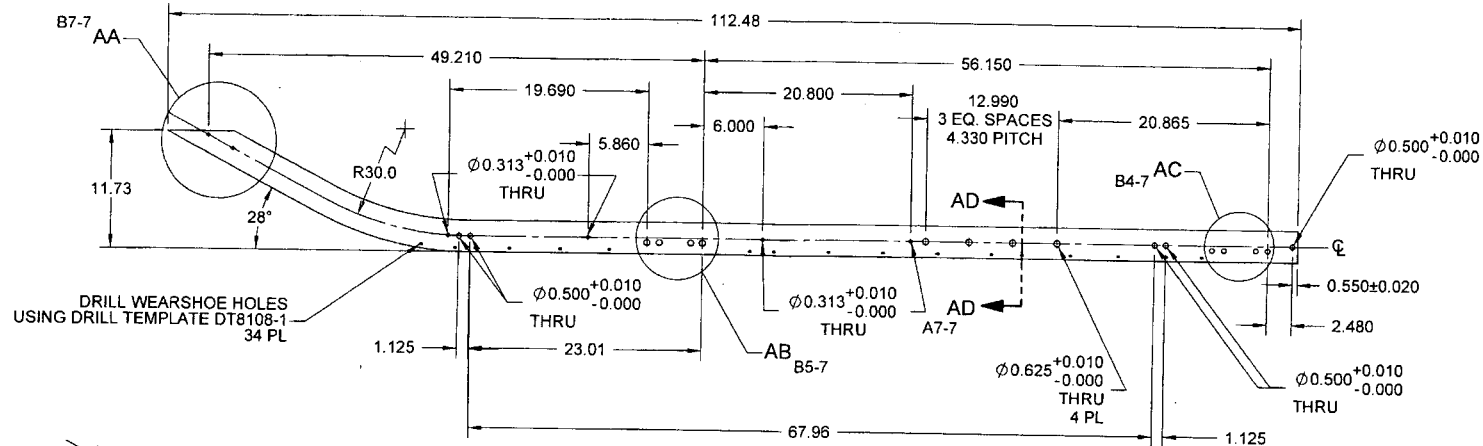


SECTION X-X
SCALE 3X, 4 PL

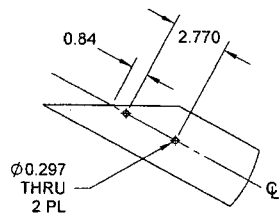
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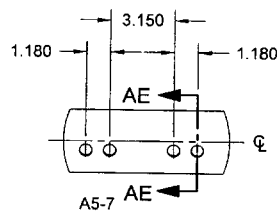
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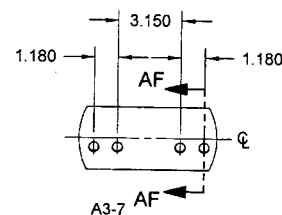
D2750-4 RH SKIDTUBE



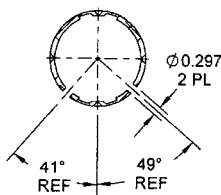
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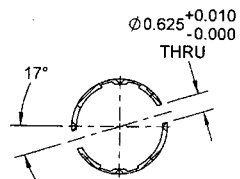
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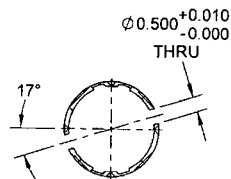
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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DE APPR.	PA	TITLE 350 SKIDTUBE ASSEMBLY
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NO. 57889

AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF 
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)

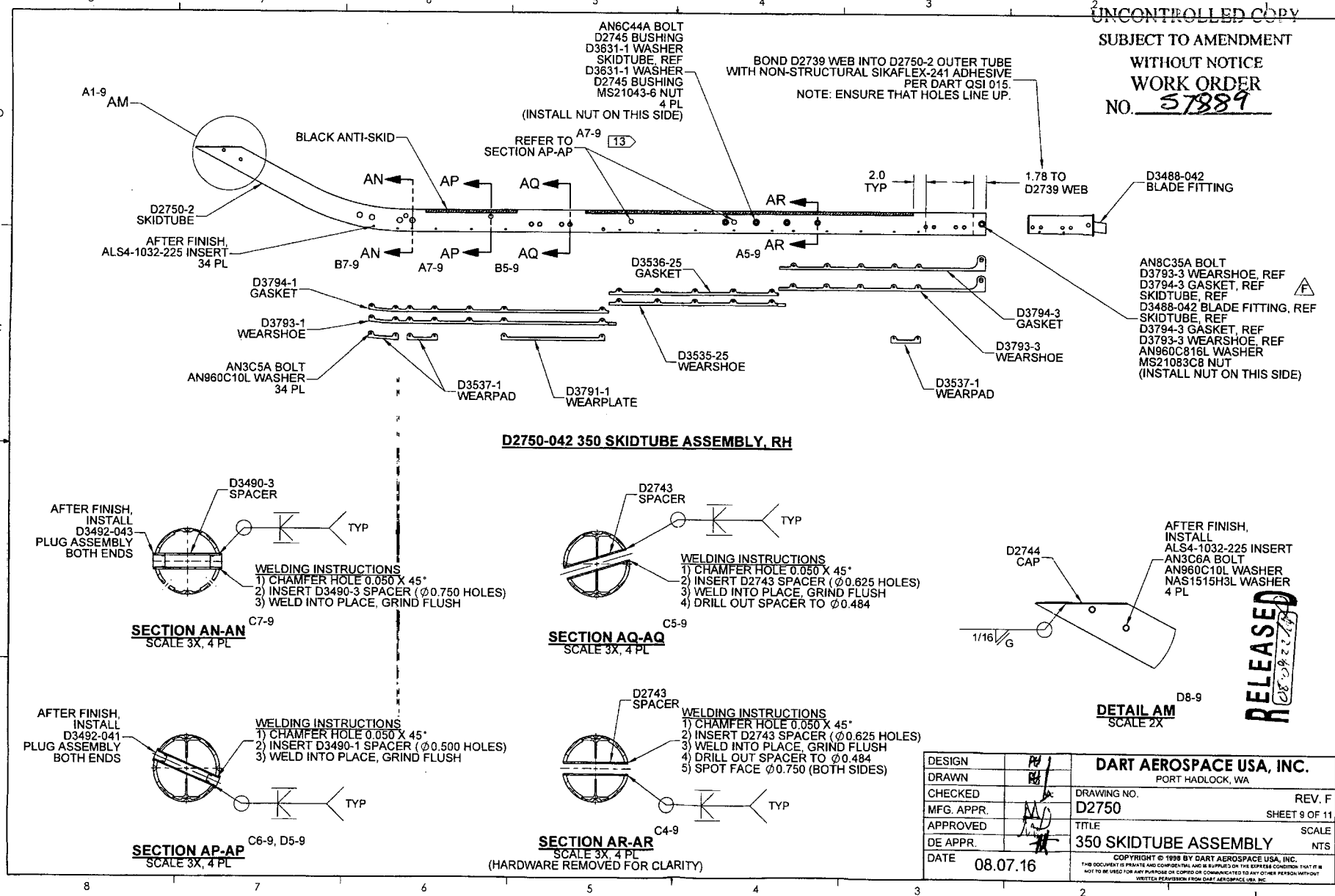


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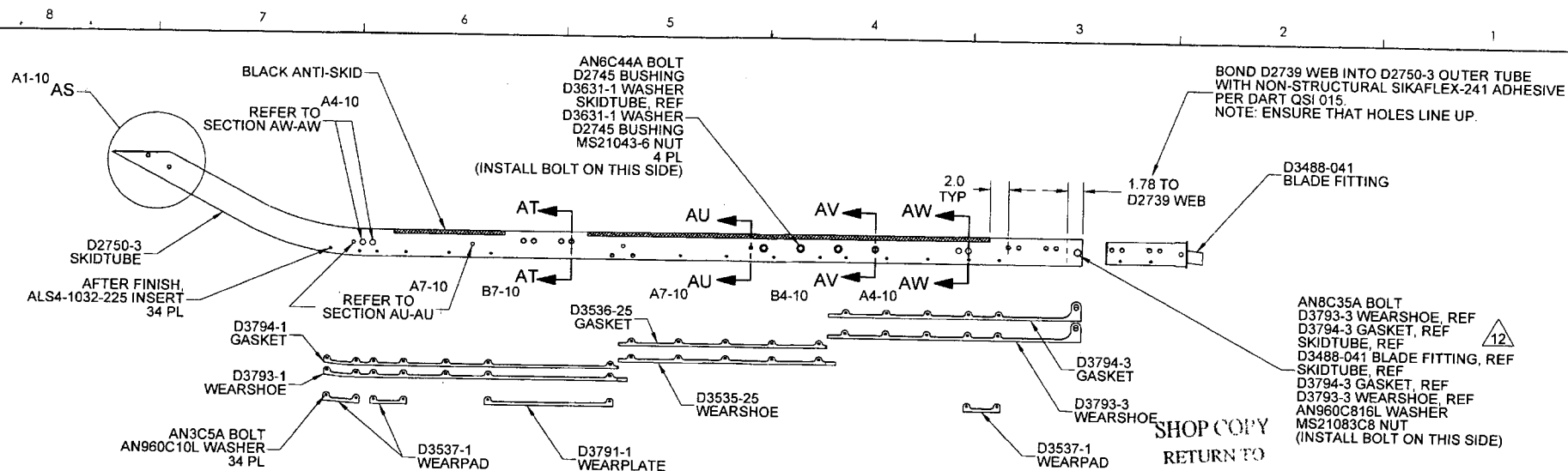
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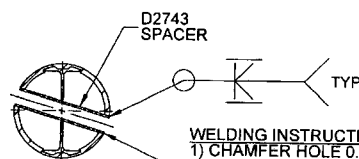


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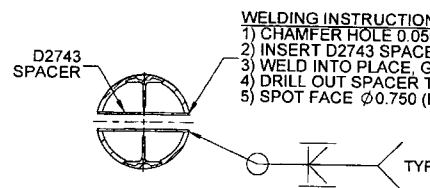


D2750-043 350 SKIDTUBE ASSEMBLY, LH

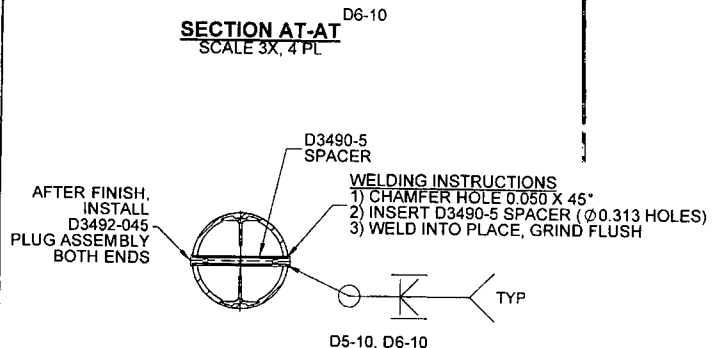
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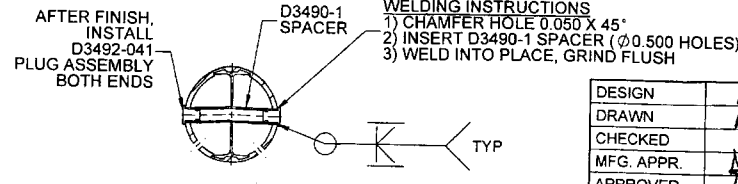
SECTION AT-AT
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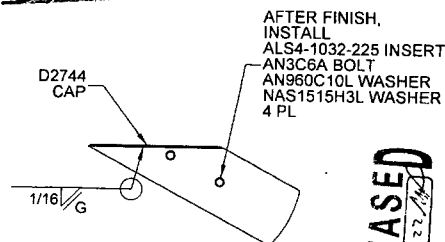
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SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



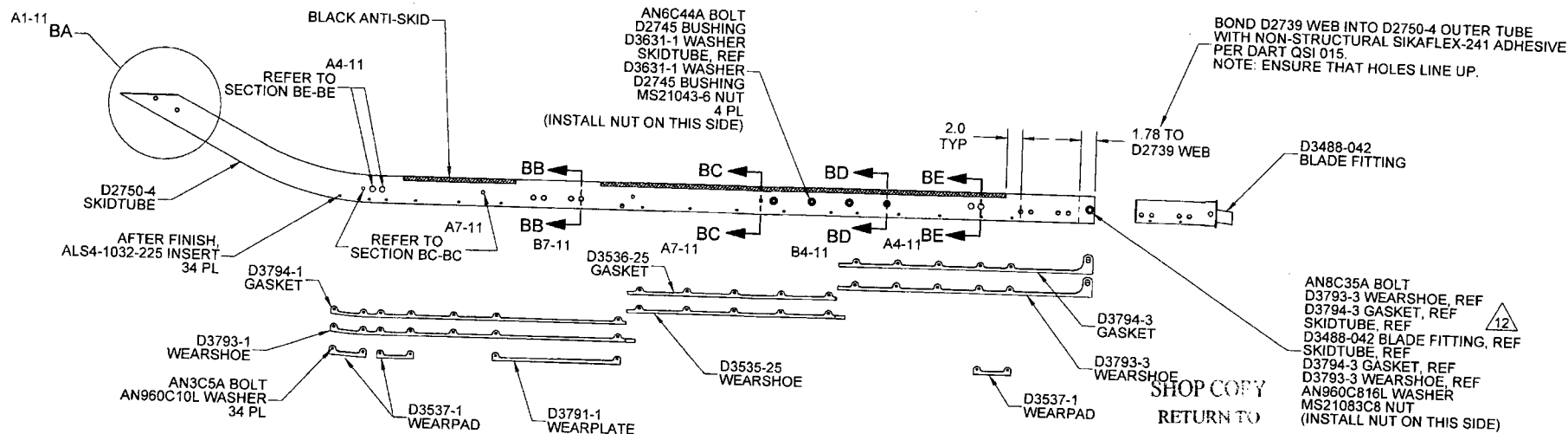
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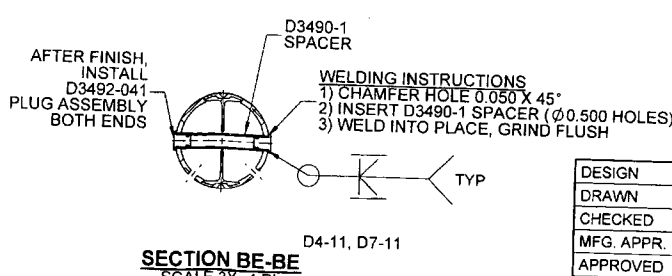
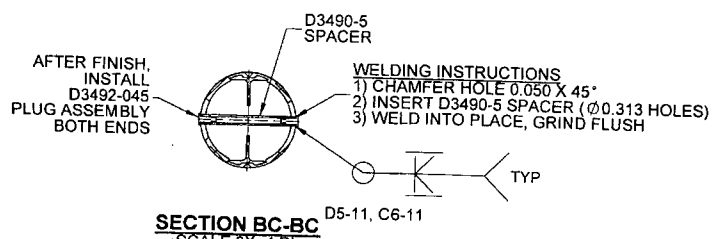
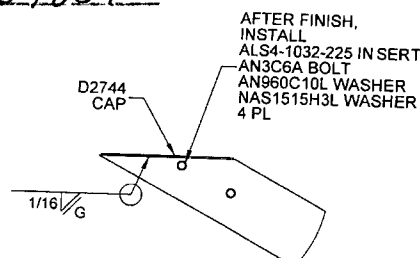
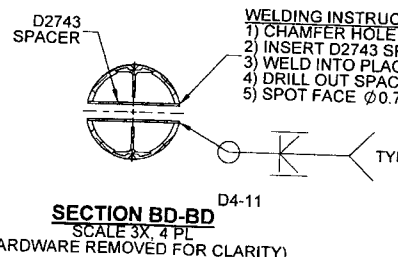
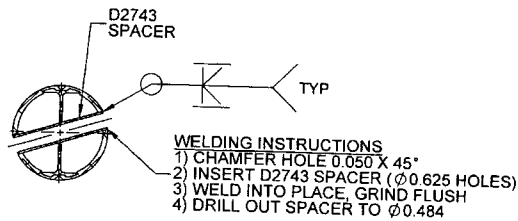


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NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 58276
Part number: D550-13-013
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Durb. Date of Test Coupon 10-02-19

Welder Barclay Elliott Date of Test Coupon 16-02-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld